

Thursday, January 12, 2017 3:40:45 PM

Page 1

7-01-25

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
		OTHER : ☐ _____							

Work Order ID 155352

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155352

Page 2

Item ID: 646.3812 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Gusset Bracket
Start Date: 1/16/2017 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 1/23/2017 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							DAS 08 9-89
130									
QC	Memo	0.03							

Quality Control

140	Outsource process-Anodize per QSI017 4.1.10.1	0.00							DAS 13 9-89
140									
Outsource4	Memo	299.99							

Outsource process - Anodize

Memo

Issue P/O to ATG : 35239

1- Black Anodize as per Dwg 646.3800

2- PRIME AS PER DWG, SEE NOTE #2

Certification of Comformity is required

150	Receive & Inspect for Damage & Mat'l Certs	0.00							
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150

Packaging

Memo

0.03

Packaging

10X SP17-02-22

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

Work Order ID 155352

Thursday, January 12, 2017 3:40:46 PM

155352

Page 3

Item ID: 646.3812

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Gusset Bracket

Start Date: 1/16/2017 Start Qty: 10.00

10

Cust Item ID:

Required Date: 1/23/2017 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

155

QC5- Inspect part completeness to step on W/O

0.00

155

QC

Memo

0.03

Quality Control

*1.1 mils thickness primer**10*DAS
38
9-89

FEB 23 2017

180

Identify as per dwg & Stock Location: *CCT102*

0.00

180

Packaging

Memo

0.02

Packaging

IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV

*10*DAS
6
9-89

FEB 23 2017

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.17

Quality Control

DAS
21
9-89

FEB 24 2017

DAS
21
9-89 FEB 23 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

Picklist Print

Thursday, January 12, 2017 3:40:45 PM

Work Order ID: 155352

155352

Parent Item: 646.3812

646 3812

Parent Item Name: Gusset Bracket

Start Date: 1/16/2017

Required Date: 1/23/2017

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 12-10-22 JLM VERIFIED:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T6A0.75X0.75X 0.060X0.062		Purchased	No				f	68.8540		1			DAS 32 9-89

***M7075T6A0 75X0 75X0 060X0**

17-01-25

7075T6 ANGLE .75" X .75" X .060" X .062"W

Location

Loc Qty

Loc Code

MAT051

68.854

123947

8.854

m136405

60

1.854

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
A	14.06.25	New Issue	KJ	

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 03697				SHEET 1 OF 1	
	DWG NO. 646.3800	REV: N/C	PREPARED BY B. PETERS	DATE: 11/14/12	EFFECT ON DWG ☐ INC. ☒ UNINC.	
	DWG TITLE: BRACKETS					
APPROVED BY: ENGR <i>[Signature]</i>		MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: NEXT ORDER		
TRANSACTION CODES (TC) A-ADD C-CREATE R-REVISE D-DELETE		REASON: ADDED ALTERNATE MATERIAL.			ECR: D-12-006	

IS

1 PRIMARY MATERIAL: 7075-T651 ALUMINUM PER AMS-QQ-A-250/12.
ALTERNATE MATERIAL: 7075-T6511 ALUMINUM PER AMS-QQ-A-200/11.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 155352 NLS

17 01-13

SHEET 1, ZONE A2 IS:

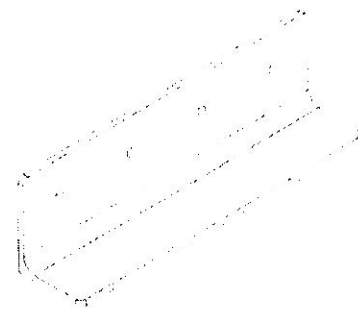
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED:				☐ RFMS ☐ MDL ☐ INSTALL INSTRUCC ☐ ICA ☐ BOM	CHANGE CATEGORY ☐ MAJOR ☒ MINOR	DER REVIEW REQUIRED ☐ YES ☒ NO

[illegible]

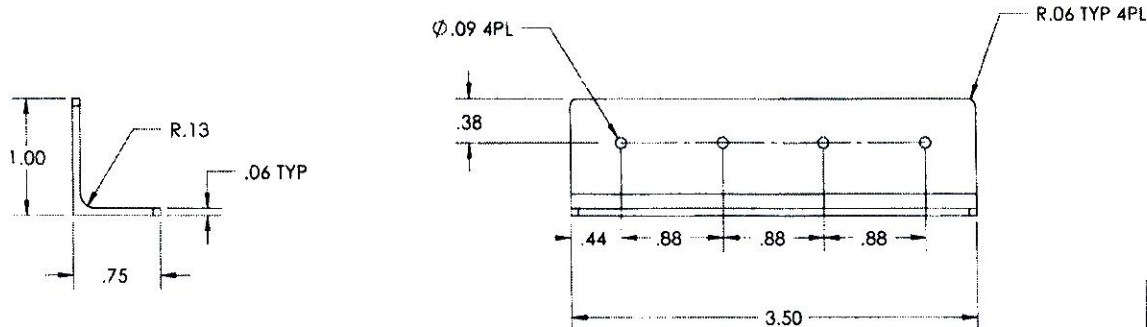
1 MATERIAL: ALUMINUM 7075-T651 AMS-QQ-A-250/12

2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III,
CLASS 2, COLOR BLACK;
CARDINAL 4860-SG PRETREATMENT PRIMER
PRIME IAW MIL-P-23377J TYPE I CLASS N

3. DEBURR AND BREAK ALL SHARP EDGES
4. IDENTIFY IAW MPP 120



646.3810



UNINCORPORATED ETC.)

03697

		646 3814	WIPER BRACKET			▲	▲
		646 3813	STR J1 BRACKET			▲	▲
		646 3812	GUSSET BRACKET			▲	▲
		646 3811	RAD-J5 BLOCY			▲	▲
		646 3810	BRACKET			▲	▲
QTY FND #		PART #		DESCRIPTION		MAF#	SPEC
QTY		PARTS LIST					
NEXT ASSY IS		ORIGINAL DATE		APICAL INDUSTRIES			
646 4000		MOD. #		2608 MAPLE HEIGHTS DR.			
		DRAWING: DIRECT		OCEANSIDE CA 92036-3512 (760)724-5300			
		DATE ORDERED		BRACKET			
		DRAWING OFFICIAL		C			
		DATE ORDERED		BRACKETS			
		CANCELLATION		1. CANCELLATION OF ORDERED QUANTITY OF PARTS 2. CANCELLATION OF 3. CANCELLATION OF 4. CANCELLATION OF 5. CANCELLATION OF			
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OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL,
INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE
RETRIEVAL SYSTEM, WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES.

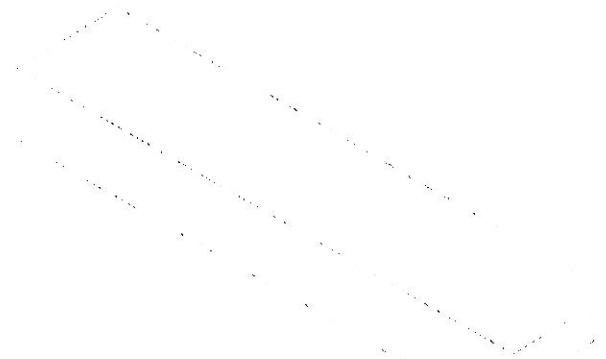
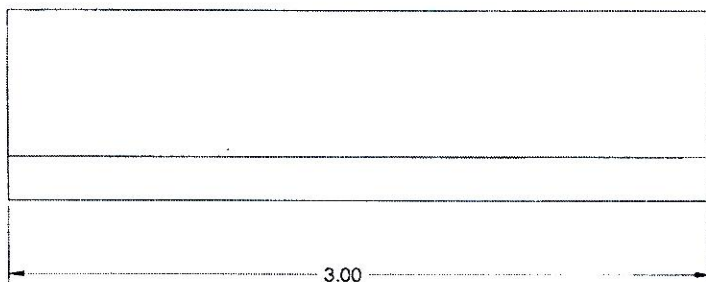
REV	DESCRIPTION	DATE	BY

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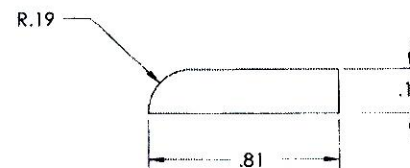
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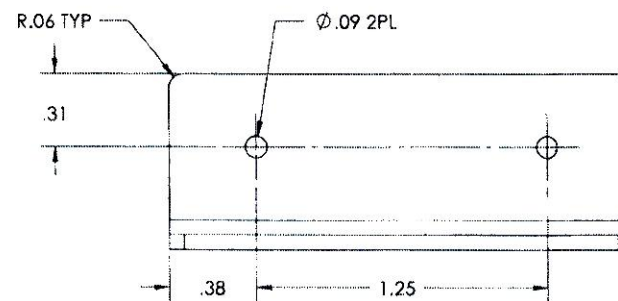
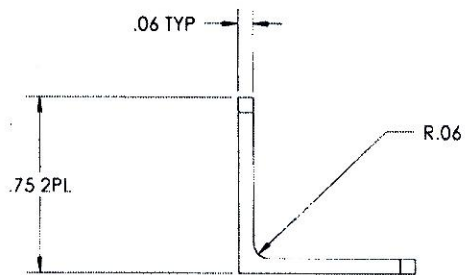
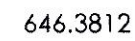


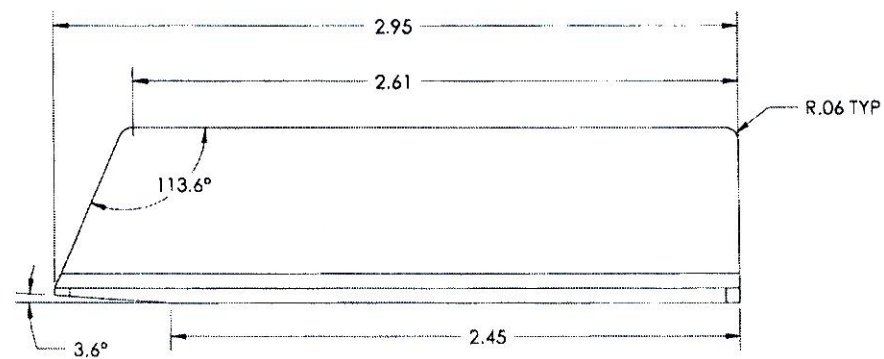
646.3811



NEXT ASSY IS:	ORIGINAL DATE	06/10/08	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR OCEANSIDE, CA 92056-3612 (760)724-5300
	IND. CAD FILE	06/10/08	
	REVISION	06/10/08	
	DESIGNED BY	06/10/08	
	APPROVED BY	06/10/08	
	PART NUMBER		BRACKETS
	PART NAME		
	SCALE		
	SHEET 2 OF 3		

PLATE	DESCRIPTION	DATE	PERIOD
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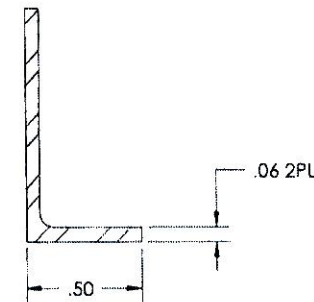
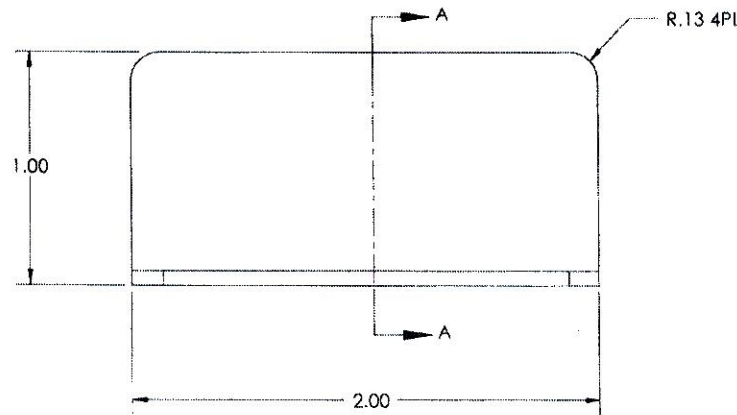
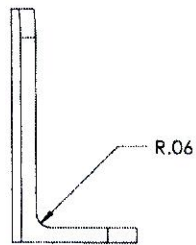
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WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES, INC.

REVISIONS			
REV	DESCRIPTION	DATE	BY/REVISED



646.3814



SECTION A-A

NEXT ASSY IS:	DESIGNED BY: CA 19-08	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760) 724-5300		
	DRAWN BY: BOWEN			
	CHECKED BY: BOWEN	BRACKETS		
	APPROVED BY: BOWEN			
OTHER COMMENTS:	NOT FOR CONSTRUCTION			
	8 DIMS			
	SCALE: NONE			
	SHEET 1 OF 1			



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO35239

Purchase Order Date 2/8/2017

PO Print Date 2/22/2017

Page Number 6 of 7

Order From :

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

VC-ATG001

Ship To :

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613-446-4544

Ship To Contact

Ship To Phone

Ship Via

Ship Acct

VENDOR'S TRUCK

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

15	71401-45	ADMIN FEE	2/24/2017	1.00	\$150.00	\$150.00
			Yes			
			2/24/2017			

Line Total: \$150.00

16	71401-45	PROCUREMENT QUALITY CLAUSES	2/24/2017	1.00	\$0.00	\$0.00
			No			
			2/24/2017			

Procurement Quality Clauses
A004 FAA-PMA /TSO
A005 RIGHT OF ENTRY
A016 PERSONNEL QUALIFICATION
A024 PROCESS CERTIFICATIONS
A025 CERTIFICATE OF CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENTS

Line Total: \$0.00

17	155352	646.3812 GUSSET REV. N/C	2/24/2017	10.00	\$0.00	\$0.00
			Yes			
			2/24/2017			

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-PRF-23377K TYPE I CLASS N

PO Instructions: PRIMER IS SUPPLIED BY DART

Note:

2/13/2017

8017-02-22



A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 912955

Date: 21-Feb-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

CHANTAL LAVOIE
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
Quantity	Description		
ea	Wearplate Black Anodize per MIL-A-8625F, Type II, Class 2 Job: 20499	PO: PO35239	Line: 14
1 ea	Part: ADMINISTRATION FEE ADMINISTRATION FEE Job: 20523	PO: PO35239	Rev: N/A Line: 15
10 ea	Part: 646.3812 ✓ Gusset bracket Hard Anodize, Type III, Class 2 (MIL-A-8625) Primer, MIL-P-23377K, Type I, Class N Job: 20689	PO: PO35239	Rev: N/C Line: 17 <i>Split 02-21</i>
8 ea	Part: 646.3311 Upper Cutter Hard Black Anodize per MIL-A-8625F, Type III, Class 2 Primer per MIL-PRF-23377K, Type I, Class N Job: 19689	PO: PO35239	Rev: N/C Line: 2
8 ea	Part: 646.3312 Center Plate Hard Black Anodize per MIL-A-8625F, Type III, Class 2 Primer per MIL-PRF-23377K, Type I, Class N Job: 19870	PO: PO35239	Rev: N/C Line: 3
8 ea	Part: 646.3313 Upper Guide Hard Black Anodize per MIL-A-8625F, Type III, Class 2 Primer per MIL-PRF-23377K, Type I, Class N Job: 19944	PO: PO35239	Rev: N/C Line: 4
8 ea	Part: 646.3717 Doubler		Rev: A



A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 912955

Date: 21-Feb-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

CHANTAL LAVOIE
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via
Quantity	Description	
	be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.	
	CERTIFICATE OF CONFORMANCE	
	A.T.G. INDUSTRIES INC. CERTIFIES THAT ALL ITEMS IN THIS SHIPMENT CONFORM TO REQUIREMENTS.	
	MADE IN CANADA.	
	SP17-02-21	